



Dart Aerospace Ltd.
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D3414-041
Job Sheet 181235



Part No: D3414-041

Job Qty: 20 ea

Part Name: Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		8/31/18	0.00	0.00	Start Up Waterjet		OK 18/07/29
100	Waterjet	20 pcs		8/31/18	0.00	1.51	Waterjet1		OK 18/07/29
120	QC	20 pcs		8/31/18	0.00	0.00	QC8		38
130	Brake NC	20 pcs		8/31/18	0.05	1.12	Brake NC 1		9-89 SB
140	Large Fab	20 pcs		8/31/18	0.00	6.13	Large Fab 1		OK 18/09/29
150	QC	20 pcs		8/31/18	0.00	0.00	QC9		EL
160	QC	20 pcs		8/31/18	0.00	0.00	QC5		EL
170	Powdercoat	20 pcs		8/31/18	0.00	0.42	Powdercoat2		BL 18-9-20
180	QC	20 pcs		8/31/18	0.00	0.00	QC3		38
190	Packaging	20 pcs		8/31/18	0.00	0.00	Packaging3-1		1-89
200	QC21-SA	20 Ea		8/31/18	0.00	0.00	QC21		SEP 2 8 2018

Part Op 100 - 1-Cut as per Dwg D3414-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 130 - 1-Deburr 2-Form using DT8254 as per Dwg D3414

140 - 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch:

170 - START TIME: 2:00 OVEN TEMPERATURE: 400 FINISH TIME: 2:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S12GA	304/316 0.100" Sheet	3.1000 sf (.155 ea)	90-Start up Operation	FM138485/5032112
D3414-3	Lug	20 Ea (1 ea)	140-Large Fab	5033842(C8)
				5066276(12)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S12GA	3	59	0
140-Large Fab	D3414-3	20	53	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches + 0.006 - 0.001	0.319 0.312		
2	Lug Bracket	1.190inches ± 0.030	1.220 1.160		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Com. ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Packaging Supplier ☐ Engineering Quality Other ☐							
Date :		Step #:		QTY Eff:		MRB (QSI042) Approval					
Description Work Order Deviation							Completed By				
							Lead hand / Supervisor Approval Verification				
							QC / QA Coordinator Approval				
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pr ☐ Bel ☐ Cen ☐ Craci ☐ Crimp ☐ Cuffs ☐ Crushin ☐ Heat Tre ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Various STC's ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER :									

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Container No: S097224
 Part: D3414-041
 Job No: 181235
 Serial No/ Batch: S097224

Date: 07/29/18

Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Various STC's ☐

3	Lug Bracket	1.000inches $\pm$ 0.030	1.030 0.970
4	Lug Bracket	3.380inches $\pm$ 0.030	3.410 3.350
5	Lug Bracket	5.350inches $\pm$ 0.010	5.360 5.340
6	Lug Bracket	6.230inches $\pm$ 0.030	6.260 6.200
7	Lug Bracket	2.500inches $\pm$ 0.010	2.510 2.490
8	Lug Bracket	0.370inches $\pm$ 0.030	0.400 0.340
9	Lug Bracket	0.100inches $\pm$ 0.010	0.110 0.090

Plex 7/24/18 9:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					